

Date: Tuesday, 3/21/2006 10:25:42 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 26303		Part Number	: D3195043	
Estimate Number	: 10384		Drawing Number	: D3195 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/21/2006	S.O. No.	Type		Drawing Revision
Prsht Rev.	: NC		: MACHINED PARTS		Material
First Issue	: N/A				Due Date
Previous Run	: 26050				: 3/28/2006
Written By	: See Comment Below				
Checked & Approved By	: JLM				
Comment	: Est Rev:A New Issue 05-11-08 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
		Comment: Qty.: 0.3150 f(s)/Unit Total : 12.6000 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.250x1.500) Identify for D3195-3 <i>M100384 X</i> (HD) Batch: <i>En 06/03/24</i>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: (1.250" x 1.500") x 3.60" long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3 2-Deburr <i>SD 06.03.25</i> 41
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SD 06.03.25</i> 41
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>BC 06.03.27</i> 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/21/2006 10:25:42 AM
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Drawing Name: BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-03-28

(41)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-03-30

(41)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/04/04 (41)

9.0 D31957

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3195-7

PAD

80
11

B 26059
B 26337

SB 06/04/04

(41)

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface

2-Bond D3195-7 into D3195-13as per Dwg D3195
A/R Contact Cement

M 1000 08

SB 06/04/04

(41)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/04/04

(41)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/34

06/04/04 (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



DD 06/04/06
u 06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

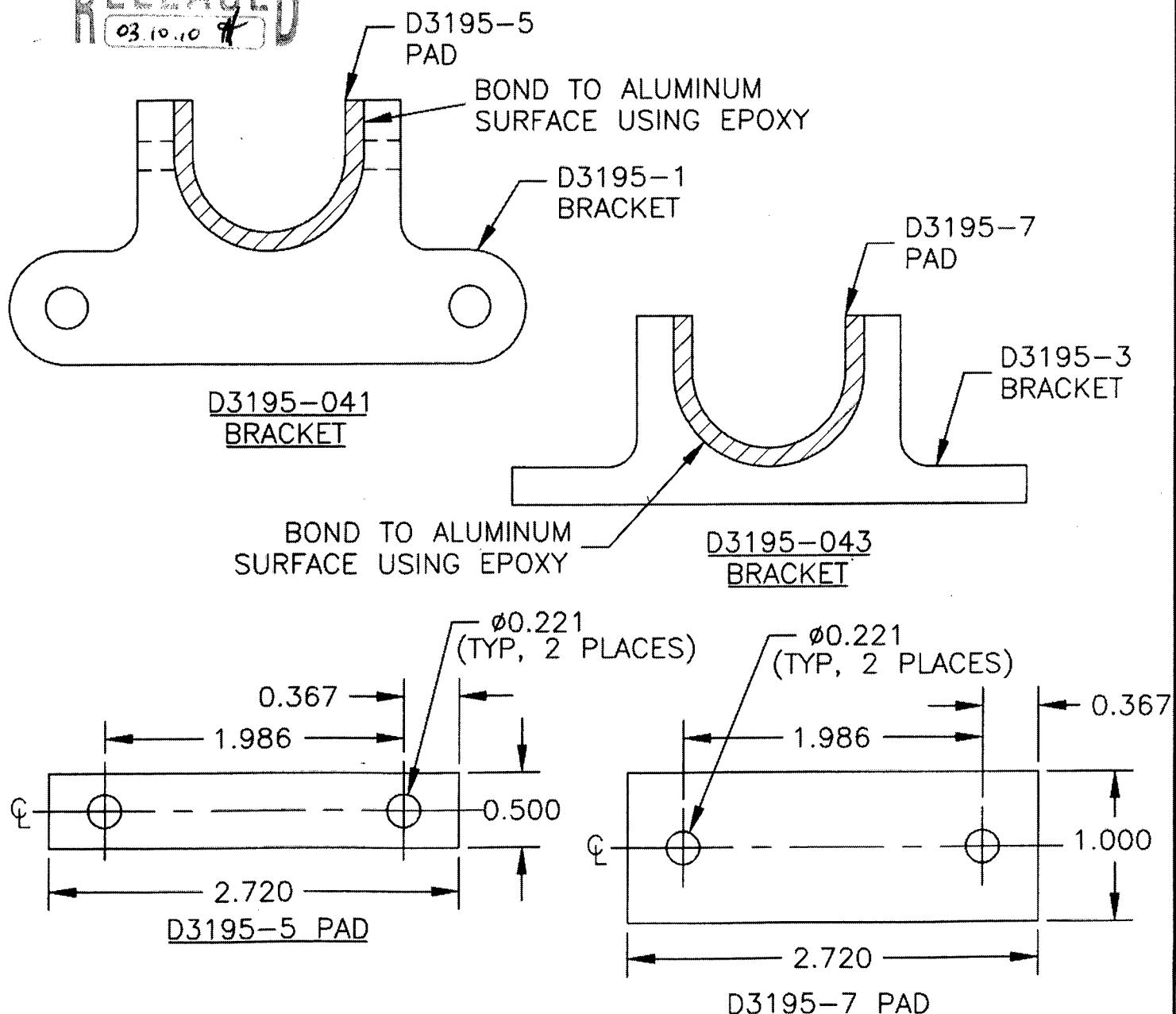
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

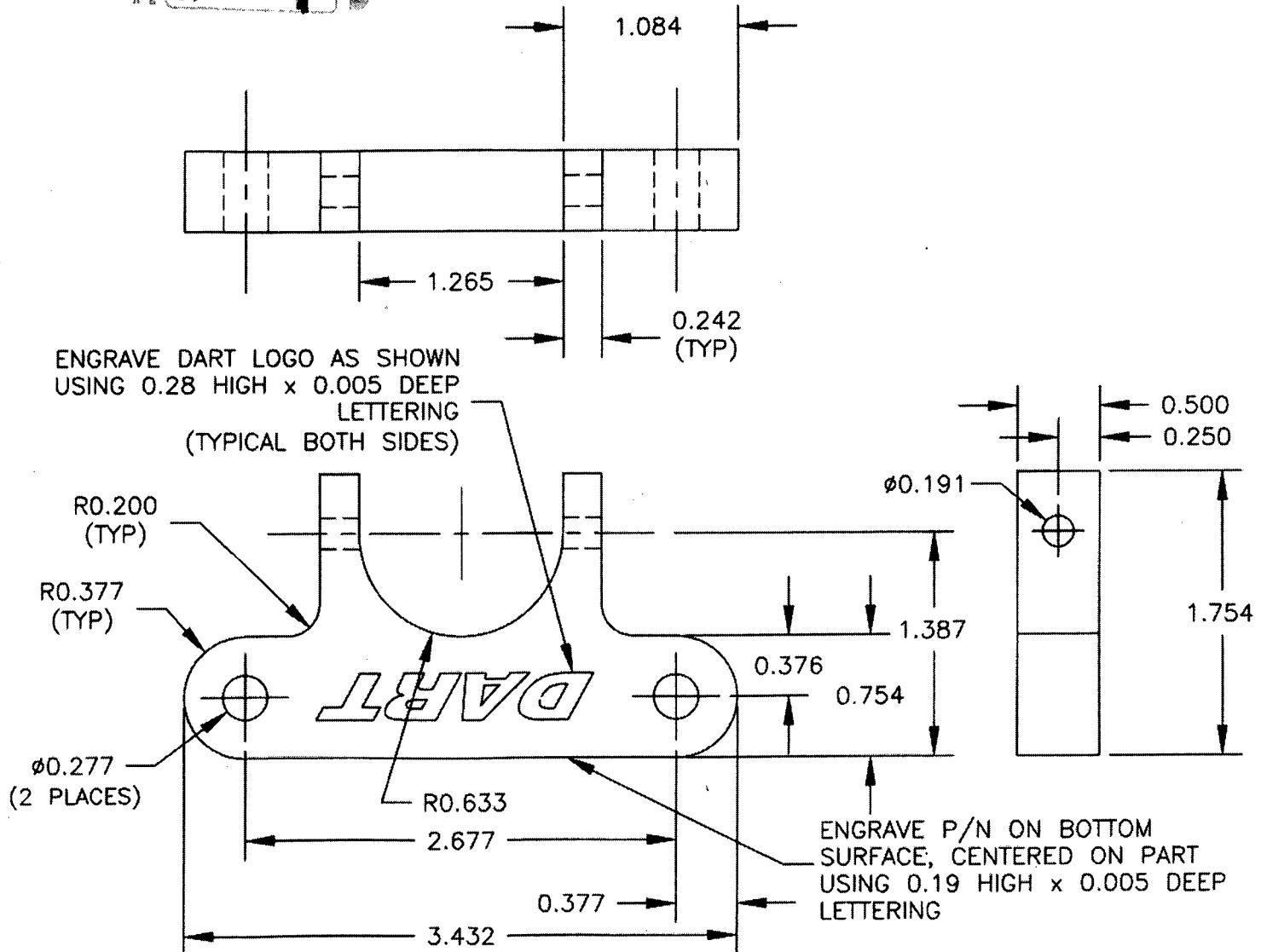
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
#	#	D3195	SHEET 1 OF 3
DATE	TITLE	SCALE	
03.06.23	BRACKET	1:1	
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

DART

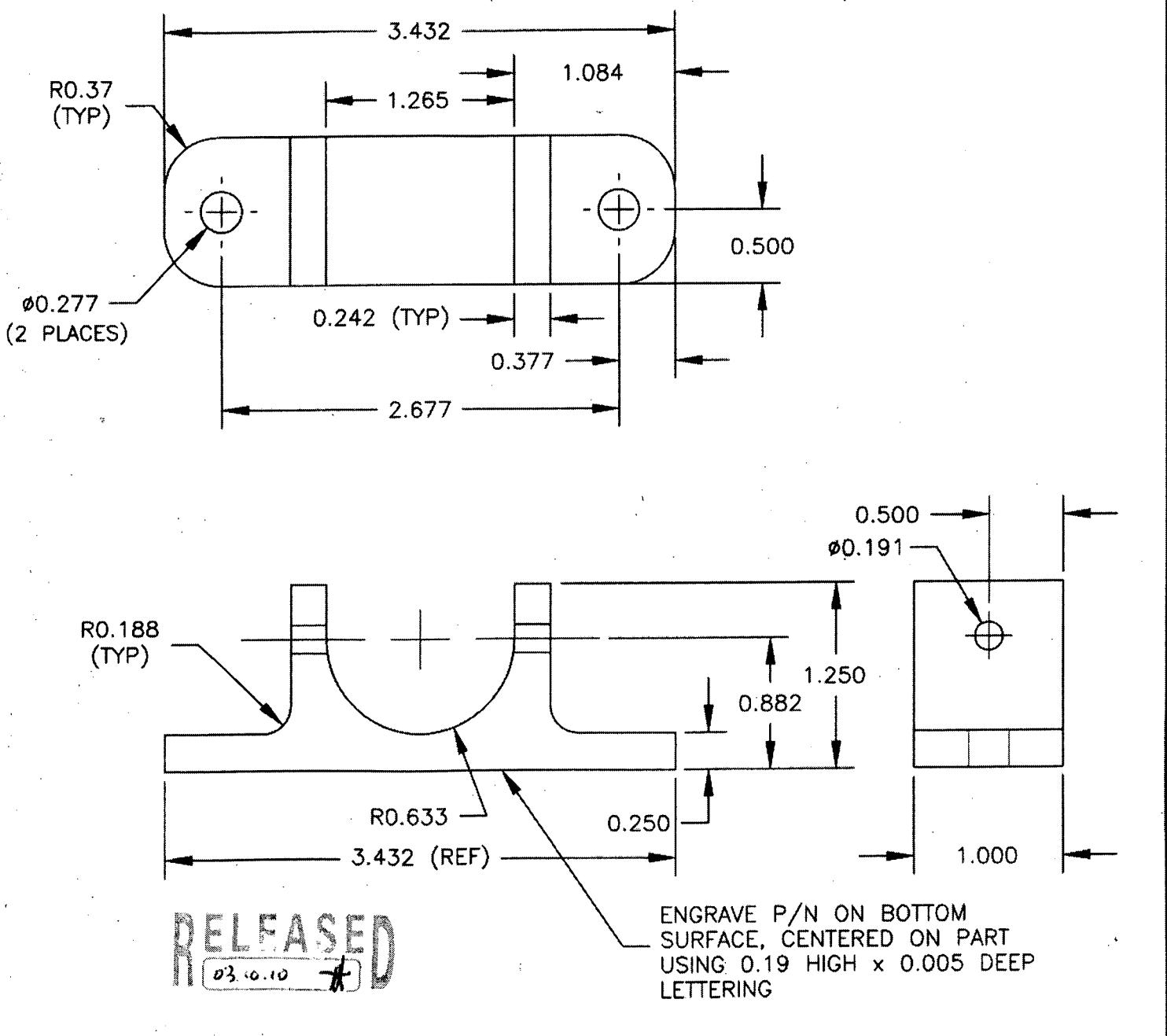
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3195	SHEET 2 OF 3
DATE	TITLE		SCALE
03.06.23	BRACKET		1:1

RELEASED
 03.06.10
**D3195-1 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3195	SHEET 3 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE	1:1

**D3195-3 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:	
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SJ	Audited by:	BC	Prototype Approval:	N/A
Date:	06.03.25	Date:	06-03-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	